



Dart Aerospace Ltd.
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D3913-041
Job Sheet 202629



Part No: D3913-041 **Job Qty:** 1 pcs

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs **Status:** New **Priority:** Medium
Job Created: 10/31/19 **Job Tracking No:**
Due Date: 11/28/19 **Created By:** Marie Lajeunesse
Type: Stock **Description:**

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	1 pcs	11/28/19		0.00	19.61	Large Fab - 1		MAL
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
110	QC 9	1 pcs	11/28/19		0.00	0.00	QC 9 - 10		DAS 24 9-89
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
120	QC 5	1	11/28/19		0.00	0.00	QC 5 - 10		DAS 24 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		



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Container No: S242562



Part: D3913-041
Job No: 202629
Serial No/Batch: S242562
Revision:
Inspector:
Exp Date:
Instructions: Various STC's

Date: 12/19/19

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					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
125 Handfinish - 2-1 Pressure-B4B	1 pcs	11/28/19	0.00	0.29	Handfinish - 2 - 1 - B4B	
					Handfinish - 2 - 2 - B4B	
					Handfinish - 2 - 3 - B4B	BK 20-01-02.
					Handfinish - 2 - 4 - B4B	
130 Powdercoat - 2 White GI(S)-B4B	1 pcs	11/28/19	0.00	0.93	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	BE B20-01-03
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
140 QC 3	1 pcs	11/28/19	0.00	0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	JAN 03 2020 40
					QC 3 - 19	9-89
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
150 Handfinish - 4-1-Assembly-B4B	1 pcs	11/28/19	0.00	0.50	Handfinish - 4 - 1 - B4B	M 20-1-6
					Handfinish - 4 - 10 - B4B	
					Handfinish - 4 - 11 - B4B	
					Handfinish - 4 - 12 - B4B	
					Handfinish - 4 - 13 - B4B	
					Handfinish - 4 - 14 - B4B	
					Handfinish - 4 - 15 - B4B	
					Handfinish - 4 - 2 - B4B	
					Handfinish - 4 - 3 - B4B	

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160 QC 5	1 pcs	11/28/19	0.00 0.00	Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
170 Packaging 3-1 - Stock - B4B	1 pcs	11/28/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	

DAS
JAN 06 2020 68
9-89

Jul 20.1.6

						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	
						Packaging 3 - 27 - B4B	
						Packaging 3 - 28 - B4B	
						Packaging 3 - 29 - B4B	
						Packaging 3 - 30 - B4B	
						Packaging 3 - 31 - B4B	
						Packaging 3 - 32 - B4B	
						Packaging 3 - 33 - B4B	
						Packaging 3 - 34 - B4B	
						Packaging 3 - 35 - B4B	
						Packaging 3 - 36 - B4B	
180 QC 21 - SA	1 pcs	11/28/19	0.00	0.00		QC 21 - SA - 21	DAS 21 9-00 JAN 06 2020
						QC 21 - SA - 70	
						QC 21 - SA - 53	

Part Op 100 - Weld per dwg A/R S.S. rod Batch: 1139015 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect Descriptions: before welding mesh*** 2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket*** 4- Weld D4672-1 blanking plates as per dwg

110 - QC9- Inspect visual per QSI004- Fusion Welds
120 - QC5- Inspect part completeness to step on W/O
125 - Pressure Wash per QSI005 4.3/ Clean and remove all markings
130 - White Gloss(Ref:4.3,5.2) per QSI005 4.3-Steel) 1- Plug holes and mask only interior of hinge (3) prior to powder coat
START: 10:30 TEMP: 325° FINISH: 10:45 521886
140 - QC3- Inspect Part Finish
150 - Assemble as per dwg - Pick Kit
160 - QC5- Inspect part completeness to step on W/O
170 - Identify as per dwg & Stock Location: _____
180 - QC21- Final Inspection - Work Order Release

Md# 013481

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 pcs (2 ea)	100-Large Fab - Basket - 1	5214321
D3913-1	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5215071
D3913-15	Wide Handle Plate	1 pcs (1 ea)	100-Large Fab - Basket - 1	5211077
D3913-3	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5224671
D3913-7	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	5220145
D3913-9	Hinge Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5223713
D3916-041	Rib Assembly	2 pcs (2 ea)	100-Large Fab - Basket - 1	5236847
D3916-5	Light Rib	3 pcs (3 ea)	100-Large Fab - Basket - 1	2x5234760 / 1x5234761
D4016-1	Hinge Half, Base	3 pcs (3 ea)	100-Large Fab - Basket - 1	5231789
D4017-7	Rib	3 pcs (3 ea)	100-Large Fab - Basket - 1	5233314
D4017-9	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	5225101
D4020-11	End Mesh, Basket	2 pcs (2 ea)	100-Large Fab - Basket - 1	5234922
D4021-1	Handle Plate	3 pcs (3 ea)	100-Large Fab - Basket - 1	5211134
D4034-041	Aft Upper Rib Assembly	1 pcs (1 ea)	100-Large Fab - Basket - 1	5238687
D4034-043	Fwd Upper Rib Assembly	1 pcs (1 ea)	100-Large Fab - Basket - 1	5229360
D4672-1	Blanking Plate	2 pcs (2 ea)	100-Large Fab - Basket - 1	5236536
M304EX0.75-16F	Expanded Metal Flat SS	32 sf (32 ea)	100-Large Fab - Basket - 1	5218454
AN3-10A	BOLT	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	5235370
D2931	Bumper	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5216435
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5196541
MS21042L3	Nut	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	5211537
NAS1149F0332P	Washer (AN960-10L)	12 Ea (12 ea)	150-Handfinish - 4-1-Assembly-B4B	5216387
D4021-5	Blanking Plate	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5241506
NAS1149FN832P	Washer (AN960-8)	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5136368

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2581	2	81	0
	D3913-1	1	10	0
	D3913-15	1	15	0
	D3913-3	1	10	0
	D3913-7	2	18	0
	D3913-9	1	9	0
	D3916-041	2	6	0
	D3916-5	3	13	0
	D4016-1	3	17	0
	D4017-7	3	31	0
	D4017-9	2	18	0
	D4020-11	2	12	0
	D4021-1	3	39	0
	D4034-041	1	8	0
	D4034-043	1	4	0
	D4672-1	2	13	0
	M304EX0.75-16F	32	871	0
	AN3-10A	6	141	0
	D2931	2	615	0
150-Handfinish - 4-1-Assembly-B4B	D4021-5	2	20	0
	MS20600-AD4W3	2	324	0
	MS21042L3	6	2,641	0
	NAS1149F0332P	12	2,924	0
	NAS1149FN832P	2	2,221	0

Part Specifications

Specifications could not be found.



Job: _____		DISPOSITION		DEPARTMENT/PROCESS							
Part No. _____		Rework Scrap Use-as-is		Skid-tube Machining Large Fab		Cross tube Small Fab Finishing		Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging		Engineering Water Jet Supplier Quality	
Date :		Sequence #:		QTY Affected :		MRB (QS1042)					
Description Work Order Deviation				Disposition							
Root Cause Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors				FAULT CATEGORY Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled Other/Details: Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread							
Completed By				Lead hand / Supervisor							
QC / QA Coordinator											